

Date: Monday, 22/12/2008 1:07:45 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206 L WEB		
Job Number	: 44231			Part Number	: D26547		
Estimate Number	: 10722			Drawing Number	: D2654 REV E1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/12/2008	S.O. No.	:	Drawing Revision	: E1		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SKIDTUBES	Due Date	: 29/12/2008 Qty: 6 Um: Each		
Previous Run	: 43665						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:e 06.04.05 Added level21 EC						

Additional Product

Job Number:



Seq#:	Machine Or Operation:	Description :	
1.0	D26007140	EXT. "I BEAM" THICK	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:
 Qty Part Number Description Batch
 1 D2600-7- 140 Web B-41591 *Awm 8-12-22* *(6Pcs)*

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

Awm 8-12-23

3.0	QC5	INSPECT WORK TO CURRENT STEP	

Comment: INSPECT WORK TO CURRENT STEP

8-12-23 (6)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Awm 8-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 1:07:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 44231

Part Number: D26547

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



1/68-12-23 (6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L-G AWPS 8-12-23

6 PCS

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/24 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



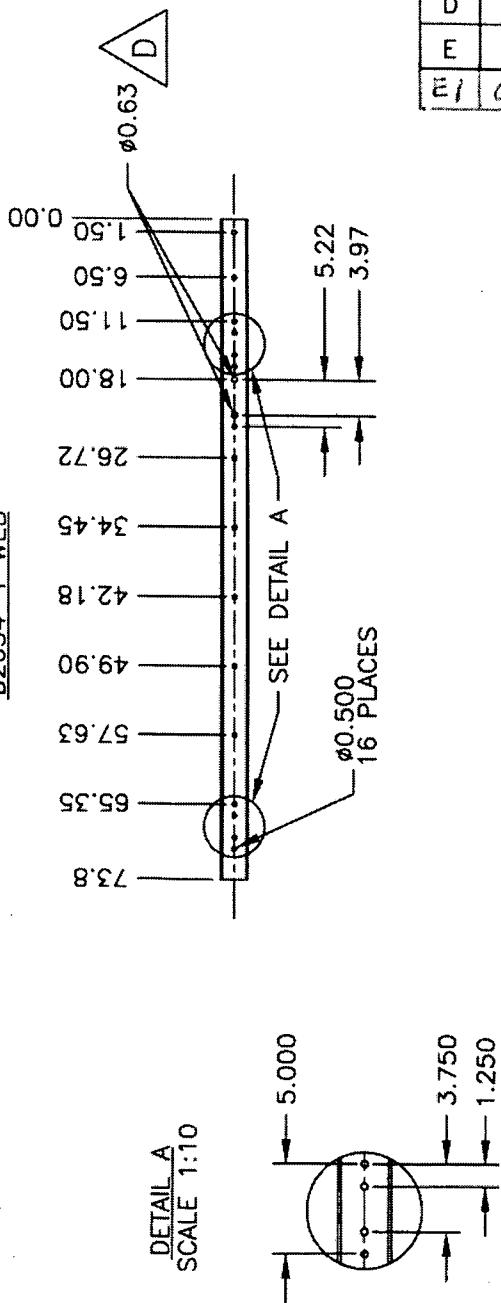
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20

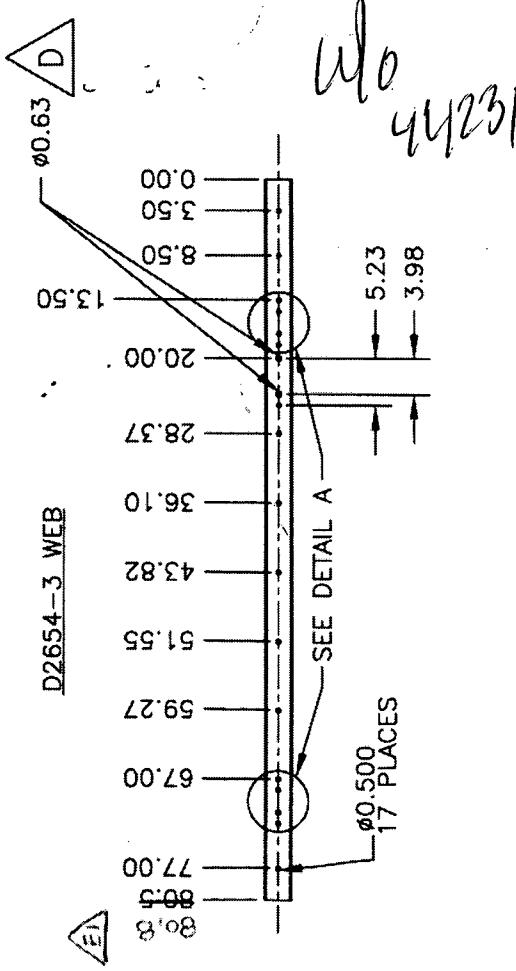
RELEASED
04.06.22

EI 04.05.26 04.06.22 PER TOOLING 90.8 was 89.5

D2654-1 WEB



D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

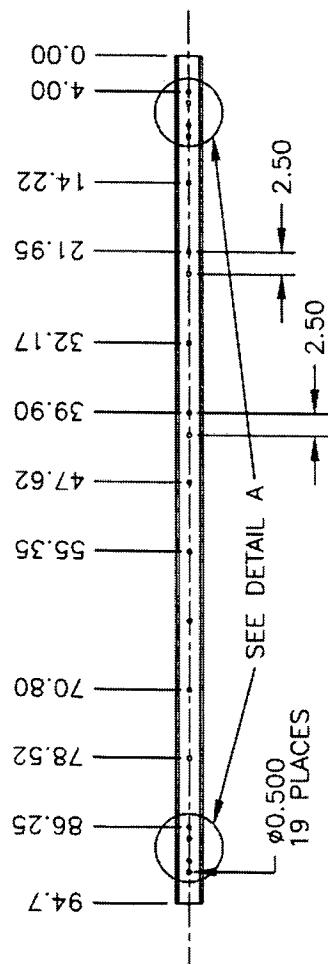


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SHEET

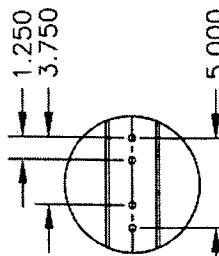
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654
DATE	04.05.26	REV. E SHEET 2 OF 2 TITLE WEB SCALE 1:20

RELEASED
04.05.22

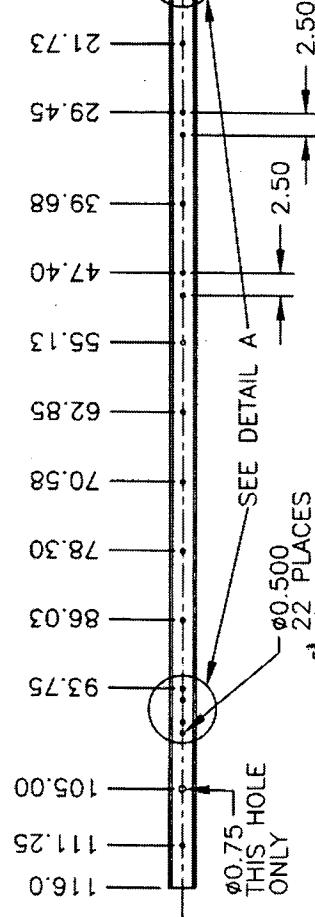
D2654-5 WEB



DETAIL A
SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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